

Ship 17/10 latest

Dart Aerospace Ltd.

Date: Tuesday, 14/10/2008 2:38:29 PM  
User: Linda Lacelle

## **Process Sheet**

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	STRUT
Job Number	42594		
Estimate Number	10220		
P.O. Number	:	Part Number	D219925
This Issue	14/10/2008	Drawing Number	D2199 / D2638
Prsht Rev.	NC	Project Number	N/A
First Issue	/ /	Drawing Revision	E1/ A
Previous Run	38454	Material	:
Written By	: <u>JW</u>	Due Date	17/10/2008
Checked & Approved By	:	Qty:	2
Comment	Est:D 02.06.10 Rmv polish & add finishNG/RF		
<b>Additional Product</b>			
Job Number:			
<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>	
1.0	M304TR0750W049	304 RD Tube .750 x .049W 	
		Comment: Qty.: 1.7675 f(s)/Unit Total : 3.5349 f(s) Material: 304/316 SS tubing 0.750" Dia. x 0.049" wall (M304TR0750W049) Batch No: <u>JW09314</u> SB 08/10/16	
2.0	BRAKE NC	NC BRAKE 	
		Comment: BRAKE NC Punch per Dwg D2199 and Spec Control Dwg D2638 SB 08/10/16	
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr <u>8/10/16(2)</u>	
4.0	QC5	INSPECT WORK TO CURRENT STEP 	
		Comment: INSPECT WORK TO CURRENT STEP <u>5-08/10/16 (2)</u>	
5.0	POWDER COATING	POWDER COATING  <u>M109152</u> <u>(2x)</u>	
		Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3  START TIME: <u>8-00</u> OVEN TEMPERATURE: <u>400</u> FINISH TIME: <u>8-30</u> <u>m-f</u> <u>08/10/17</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 42594

Part Number: D219925

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FZ 08/10/17 (2)

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 264

AS 08/10/17 (2)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



08/10/17 JJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MM  
08/10/20

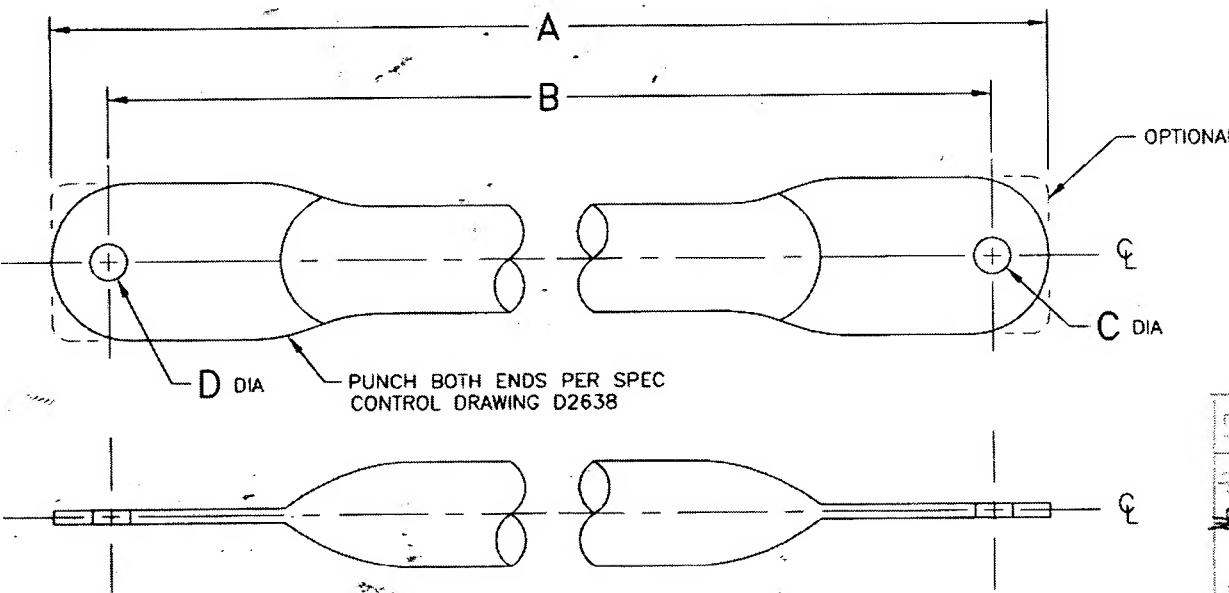
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries



	A	B	C	D
D2199-1,	18.30	17.50	0.257	0.257
D2199-3	5.80	5.00	0.257	0.257
D2199-5	22.64	21.84	0.257	0.316
D2199-7	14.74	13.94	0.257	0.257
D2199-9	16.52	15.72	0.257	0.257
D2199-11	23.60	22.80	0.257	0.316
D2199-13	15.96	15.16	0.257	0.257
D2199-15	17.57	16.77	0.257	0.257
D2199-17	28.05	27.25	0.257	0.316
D2199-19	18.90	18.10	0.257	0.257
D2199-21	10.80	10.00	0.257	0.257
D2199-23	26.18	25.38	0.257	0.316
D2199-25	19.93	19.13	0.257	0.257
D2199-27	27.34	26.54	0.257	0.316
D2199-29	21.11	20.31	0.257	0.257

(B) (B) (C) (C) (E)

00.10.13  
00.10.13

NOTES:

1. MAKE PER TEMPLATE DT2199-XX WHERE XX IS THE RESPECTIVE DASH NUMBER
2. MATERIAL: AISI 304/316 STAINLESS STEEL TUBE Ø0.750 x 0.049 WALL
3. FINISH: POWDER COAT WHITE (4.3.5.2) PER DART 08.04.06.4.3/EP

DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. E
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
DATE		TITLE	SCALE
98.04.28		STRUT DETAILS	NTS
A	1993	NEW ISSUE	
B		ADDED - 11, - 13, AND - 15	
C		ADDED - 17 AND - 19	
D		ADDED - 21	
E	98.04.28	ADDED - 23 AND - 25 PER TSR A565M ADDED TEMPLATE & SPEC CTRL DWG REDRAWN IN CAD	

WJD  
4/29/93